







# SELECTION GUIDE

# X-SPEED ROUGHER END MILLS

⊙ : Excellent  
○ : Good

ITEM	MODEL	DESCRIPTION	SIZE		Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		High Hardened Steels	Copper	Graphite	Cast Iron	Aluminum	Stainless Steels	Titanium	Inconel
			MIN	MAX	~HRc20	HRc20-30	HRc30~40	HRc40~45	HRc45~55	HRc55~70							
<b>INCH</b>																	
<b>G907</b> <b>G928</b>		CARBIDE, 4&5 FLUTE STUB LENGTH ROUGHING CORNER RADIUS	0.14	0.1	⊙	⊙	⊙	○			○		⊙		○		
<b>G908</b> <b>G929</b>		CARBIDE, 4&5 FLUTE REGULAR LENGTH ROUGHING CORNER RADIUS	0.14	0.1	⊙	⊙	⊙	○			○		⊙		○		
<b>G909</b> <b>G930</b>		CARBIDE, 4&5 FLUTE EXTENDED REACH ROUGHING CORNER RADIUS	0.14	0.3/4	⊙	⊙	⊙	○			○		⊙		○		
<b>METRIC</b>																	
<b>G9D75</b>		CARBIDE, 4&5 FLUTE MULTIPLE HELIX SHORT LENGTH ROUGHING CORNER RADIUS	06.0	020.0	⊙	⊙	⊙	○			○		⊙		○		
<b>G9D76</b>		CARBIDE, 4&5 FLUTE MULTIPLE HELIX LONG LENGTH ROUGHING CORNER RADIUS	06.0	020.0	⊙	⊙	⊙	○			○		⊙		○		
<b>G9D77</b>		CARBIDE, 4&5 FLUTE MULTIPLE HELIX LONG REACH ROUGHING CORNER RADIUS	06.0	020.0	⊙	⊙	⊙	○			○		⊙		○		



**X-SPEED ROUGHER  
END MILLS**

**RECOMMENDED CUTTING CONDITIONS**

CBN  
END MILL

i-Xmill  
END MILL

X5070  
END MILLS

4G MILLS  
END MILLS

**X-SPEED  
ROUGHER  
END MILLS**

X-POWER  
END MILLS

JET-POWER  
END MILLS

V7 MILL STEEL  
END MILLS

V7 MILL INOX  
END MILLS

ALU-POWER  
END MILLS

D-POWER  
END MILLS

STANDARD  
CARBIDE  
END MILLS

TANK-POWER  
END MILLS

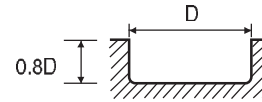
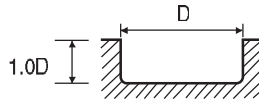
STANDARD  
COBALT  
& HSS  
END MILLS

TECHNICAL  
DATA

**CARBIDE, 4&5 FLUTE MULTIPLE HELIX CORNER RADIUS  
- SLOTting**

**G907, G928, G908, G929, G909, G930, G9D75, G9D76, G9D77 SERIES**

MATERIAL		ALLOY STEELS, CARBON STEELS TOOL STEELS CAST IRON		ALLOY STEELS, CARBON STEELS TOOL STEELS, CAST IRON PREHARDENED STEELS	
HARDNESS		~ HRc25		HRc25 ~ HRc40	
DIAMETER		RPM	FEED	RPM	FEED
INCH	METRIC				
1/4	6.0	12000	61.0	10600	43.3
5/16	8.0	9000	65.0	8100	46.5
3/8	10.0	7200	65.0	6400	46.5
1/2	12.0	6000	60.6	5400	44.9
5/8	16.0	4500	59.1	4100	41.3
3/4	20.0	3600	52.4	3200	35.4
1	-	2900	46.4	2600	32.5

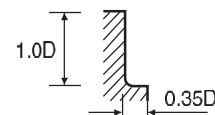
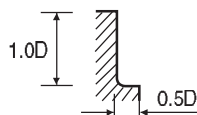


RPM = rev./min.  
FEED = inch/min

**CARBIDE, 4&5 FLUTE MULTIPLE HELIX CORNER RADIUS  
- SIDE CUTTING**

**G907, G928, G908, G929, G909, G930, G9D75, G9D76, G9D77 SERIES**

MATERIAL		ALLOY STEELS, CARBON STEELS TOOL STEELS CAST IRON		ALLOY STEELS, CARBON STEELS TOOL STEELS, CAST IRON PREHARDENED STEELS	
HARDNESS		~ HRc25		HRc25 ~ HRc40	
DIAMETER		RPM	FEED	RPM	FEED
INCH	METRIC				
1/4	6.0	15800	101.2	14300	72.8
5/16	8.0	11900	106.3	10700	76.8
3/8	10.0	9500	106.3	8500	76.8
1/2	12.0	8000	101.2	7100	72.8
5/8	16.0	6000	96.5	5400	69.9
3/4	20.0	4800	84.3	4300	59.1
1	-	3800	75.3	3400	49.3



RPM = rev./min.  
FEED = inch/min